

Date: Monday, 11/6/2006 2:39:57 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE	
Job Number	: 29343		Part Number	: D29322	
Estimate Number	: 10832		Drawing Number	: D2932 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/6/2006 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/24/2006	
Previous Run	: 29231		Qty:	10	
Written By	: JF		Um:	Each,	
Checked & Approved By	: JF 06.11.06				
Comment	: Est: B 06.06.26 New DWG rev (mpp 2069) EC				

Additional Product

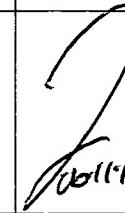
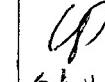
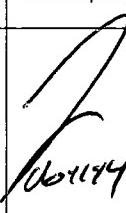
Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0 x 6.25 X 7.88 R25346 x 2 Grain Along Long 7.88 Length Batch No: BQ5348 x 8	JF 06/11/13
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1. Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr	SD/JF 06/11/13
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	SD 06.11.13 FJ
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	SD 06.11.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
:							
:							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/12/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/07	2	TOOL RAD IN FLANGE POCKETING IS R0.188 INSTEAD OF R0.25	 06/11/07 per QSI 042	USE R0.188 TOOL FOR FLANGE POCKETING AS MARKED UP ON DWG	 06/11/14	 06/11/14	 06/11/07 per QSI 042	 06/11/07
:								
:								

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:39:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 29343

Part Number: D29322

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

9mL 06/11/22 10

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a-n 06/11/22 10x

7.0 POWDER COATING POWDER COATING



M 102301

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-b/ 06/12/19 10x

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10/12/20 10

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *52472*

10/12/20 10

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/12/20

Job Completion



Locel12/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29343
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.125"	.119	.119	.115		
B	0.100	0.140		.125"	.119	.118	.118		
C	0.100	0.140		.115"	.118	.116	.116		
D	0.210	0.230		.224"	.225	.221	.228		
E	1.245	1.255		1.252"	1.25	1.256	1.250		
F	1.245	1.255		1.251"	1.250	1.250	1.251		
G	2.495	2.505		2.502"	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.582"	1.578	1.577	1.578		
J	2.495	2.505		2.501"	2.501	2.501	2.501		
K	0.257	0.262	DT8683	.258"	.258	.258	.258		
L	0.312	0.317	DT8686	.314"	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.119"	.122	.120	.127		
O	0.540	0.560		.545"	.550	.548	.551		
P	0.490	0.510		.504"	.501	.501	.508		
Q	3.715	3.725		3.719"	3.720	3.720	3.721		
R	2.470	2.510		2.495"	2.493	2.493	2.493		
S	0.240	0.270		.252"	.250	.251	.249		
T	0.100	0.180		.140"	.140	.140	.140		
U	1.625	1.635		1.632"	1.630	1.630	1.630		
V	1.362	1.372		1.371"	1.367	1.369	1.366		
W	0.316	0.321	DT8690	.319"	.319	.319	.319		
X	1.125	1.145		1.134"	1.139	1.137	1.144		
Y	1.565	1.585		1.575"	1.577	1.575	1.582		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F.	/ SD	Audited by:	J.W.
Date:	06/11/13	06.11.14	Date:	06/11/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

DART AEROSPACE LTD	Work Order:	29343
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.125	.124	.126		
B	0.100	0.140		.123	.124	.124	.124		
C	0.100	0.140		.120	.118	.122	.123		
D	0.210	0.230		.228	.227	.227	.226		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.498	2.501	2.501	2.501		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.314	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.126	.120	.120	.120		
O	0.540	0.560		.553	.552	.551	.551		
P	0.490	0.510		.498	.495	.499	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.498	2.493	2.493	2.493		
S	0.240	0.270		.256	.260	.259	.257		
T	0.100	0.180		.170	.170	.170	.170		
U	1.625	1.635		1.630	1.630	1.620	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.318	.319	.319	.319		
X	1.125	1.145		1.134	1.134	1.134	1.134		
Y	1.565	1.585		1.574	1.574	1.574	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD	Audited by:	On
Date:	06-11-14	Date:	06-11-22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

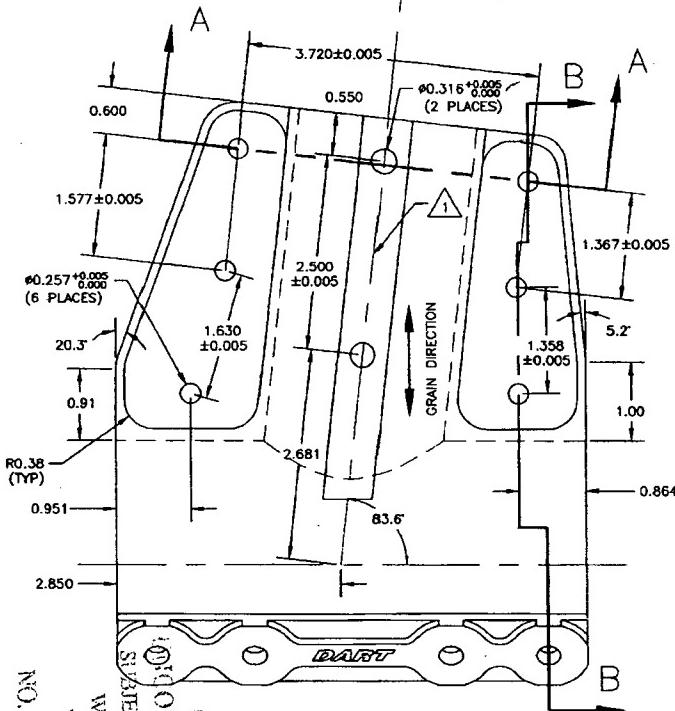
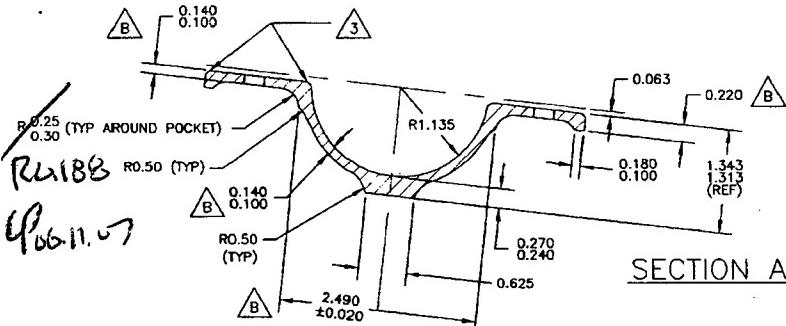
DART AEROSPACE LTD	Work Order:	29343
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

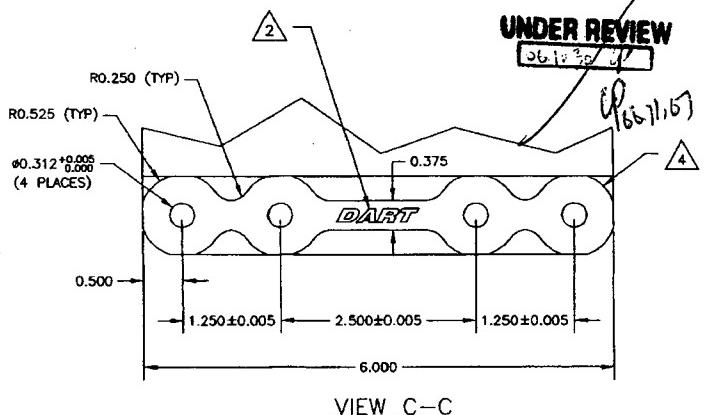
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.124	.124				
B	0.100	0.140		.124	.124				
C	0.100	0.140		.122	.123				
D	0.210	0.230		.226	.226				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.501	2.501				
H	0.510	0.515		.514	.514				
I	1.572	1.582		1.578	1.574				
J	2.495	2.505		2.498	2.501				
K	0.257	0.262	DT8683	.258	.258				
L	0.312	0.317	DT8686	.314	.317				
M	0.235	0.240		.237	.237				
N	0.100	0.140		.120	.120				
O	0.540	0.560		.552	.552				
P	0.490	0.510		.500	.498				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.493	2.493				
S	0.240	0.270		.257	.257				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	.319	.319				
X	1.125	1.145		1.134	1.135				
Y	1.565	1.585		1.574	1.575				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD	Audited by:	Paul
Date:	06.11.14	Date:	06/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#



NO.
WORK ORDER
343
SUBJECT TO AMENDMENT
WITHOUT NOTICE
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED
00.05.31.77



B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	RF	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2932 REV. B SHEET 1 OF 1
DATE	00.05.29	TITLE SADDLE OUTSIDE SCALE 2.3

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DART AEROSPACE USA, INC.

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.
See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge

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No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

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Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006